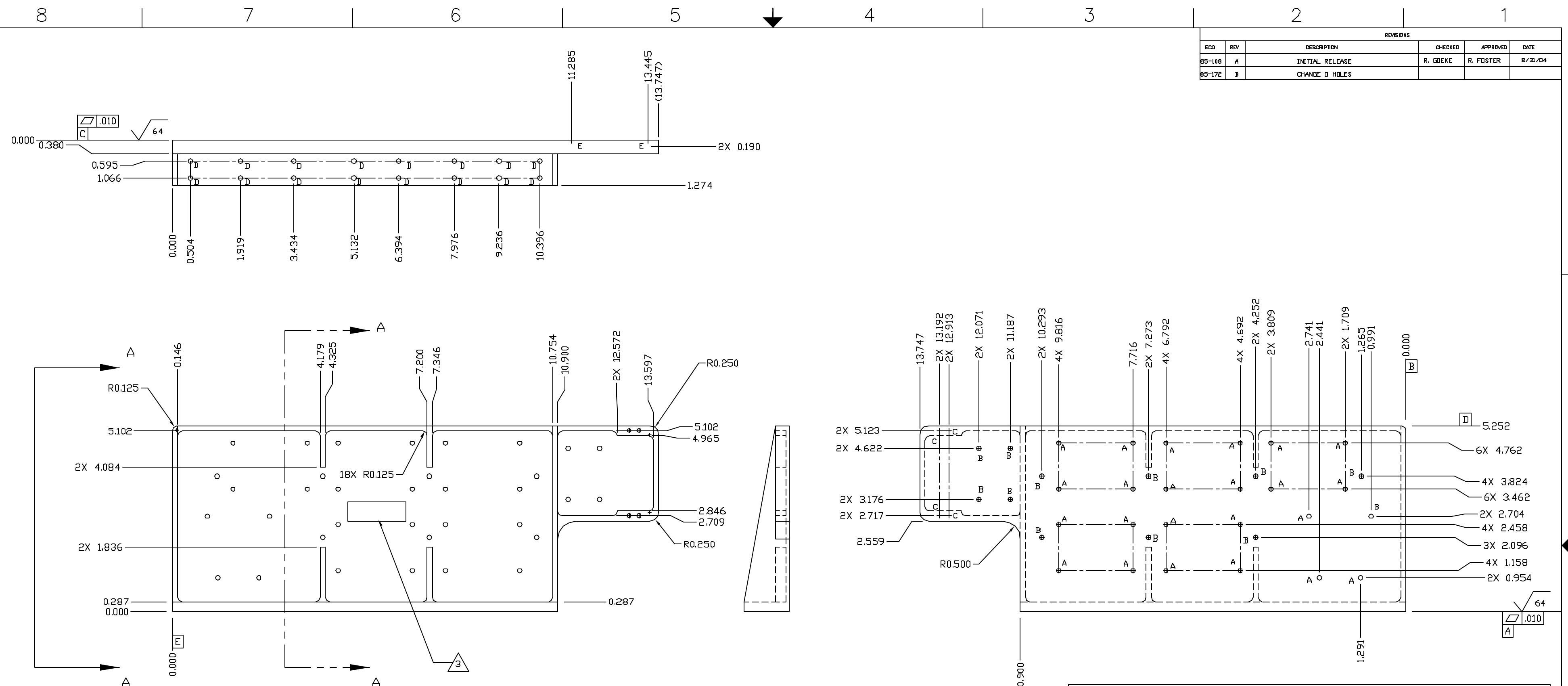


REVISIONS					
ECO	REV	DESCRIPTION	CHECKED	APPROVED	DATE
85-108	A	INITIAL RELEASE	R. GDEKE	R. FOSTER	8/31/04
85-172	B	CHANGE D HOLES			



- NOTES:
- SERIALIZE TRAINING UNIT STARTING WITH 101 AND FLIGHT UNITS WITH 30X.
  - CLEANLINESS REQUIREMENTS PER SN-C-0005 LEVEL VC-SENSITIVE.
  - ENGRAVE IN .12 HIGH CHARACTERS, P/N, REV AND SERIAL NUMBER PRIOR TO PLATING. LOCATE APPROXIMATELY WHERE SHOWN.
  - ELECTROLESS NICKEL PLATE PER ASTM B 733, TYPE 1, CLASS 4. MASK TAPPED HOLES. DIMENSIONS ARE AFTER PLATING.
  - DEBUR AND BREAK SHARP EDGES. FILLET RADIUS .010

HOLE CHART			
HOLE	QTY	TOLERANCE	DESCRIPTION
A	24	$\phi \pm 0.005$ M C A B	$\phi 0.157 \pm 0.003$ THRU
B	11	$\phi \pm 0.010$ M C A B	$\phi 0.144 \pm 0.003$ THRU
C	4	$\phi \pm 0.010$ M C A B	$\phi 0.120^{+0.003}_{-0.002}$ THRU, $\sqrt{\phi 0.155 \pm 0.015 \times 120^\circ \pm 5^\circ}$ , TAP THRU FOR .112-40 UNC HELICAL STI.
E	2	$\phi \pm 0.010$ M D C E	INSTALL INSERT (FN 3) 3/4 - 1 1/2 PITCH BELOW SURFACE. INSTALL INSERT AFTER FINISH.
D	16	$\phi \pm 0.005$ M A B C	$\phi 0.154 \pm 0.003$ THRU, $\sqrt{\phi 0.158, .60^\circ}$

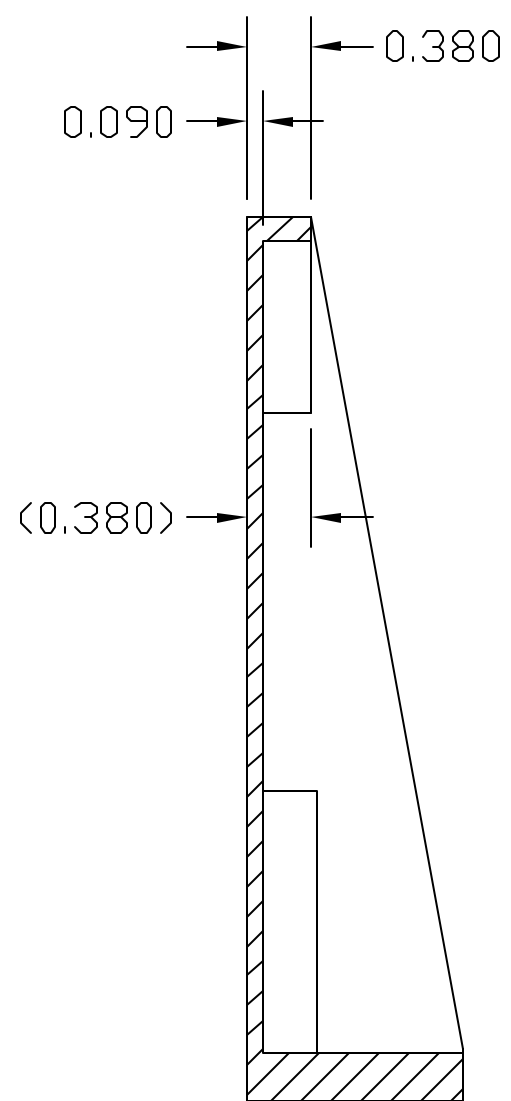
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCE: ANGLES +/- 1° 3 PLACE DECIMALS +/- .005 2 PLACE DECIMALS +/- .01		NAME	DATE	Massachusetts Institute of Technology Center for Space Research VOILA
MATERIAL 6061 T6 AL.		DRAWN M. SMITH	5/19/04	
85-30317	VOILA	CHECKED R. GDEKE	8/31/04	PANEL, MOUNTING POWER DISTRIBUTION
NEXT ASSEMBLY	USED ON	APPROVED R. FOSTER	8/31/04	
APPLICATION		RELEASED D. GAGE	8/31/04	SIZE J
		NOTE 4 FINISH		FSCM NO. 80230
				DWG NO. 85-30317.06
				SCALE 1:1
				SHEET 1 OF 2

8 7 6 5 4 3 2 1

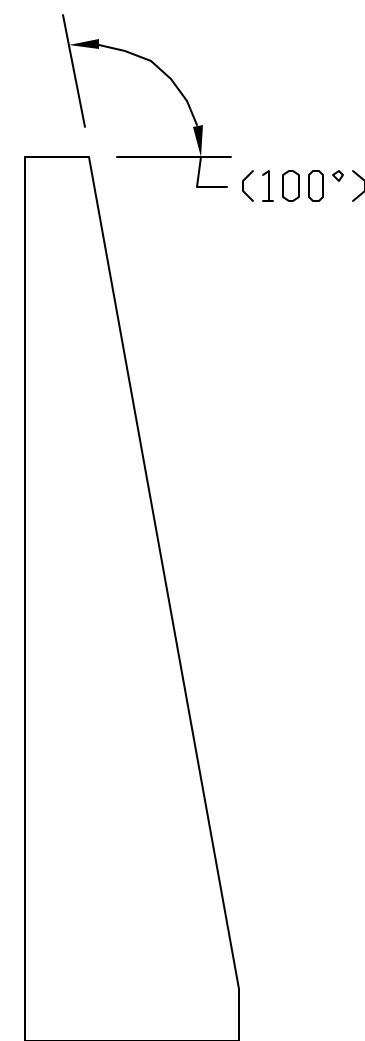
REVISIONS					
ECO	REV	DESCRIPTION	CHECKED	APPROVED	DATE
85-108	A	SEE SHEET 1	R. GÖEKE	R. FOSTER	9/21/04
85-172	B	SEE SHEET 1			

D  
C  
B  
A

D  
C  
B  
A



SECTION A-A



VIEW A-A

Massachusetts Institute of Technology  
Center for Space Research  
VOILA

PANEL, MOUNTING  
POWER DISTRIBUTION

SIZE D	FORM NO. 80230	DWG NO. 85-30317.06	REV B
SCALE 1:1	SHEET 2 OF 2		

8 7 6 5 4 3 2 1